

Slp Monday July 11

Work Order ID 71619

Thursday, July 07, 2011 9:00:48 AM



PRELIMINARY ISSUE

Page 1

Item ID: D3199-4

Accept



Setup Start



Revision ID:

Item Name: Bracket, Fwd RH

Stop



Start Date: 7/7/2011 Start Qty: 1.00

Required Date: 7/11/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3199

PE1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: *PE1*

Prog Rev: *PE1*

Deburr if required

B11-7-7

③

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-7-7

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Page 2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00 - inspect to PE 1

0.00

Dug only

8/17/12

130



Brake NC

Brake NC

Bend as per dwg
Small Fab

Memo

0.00

0.00

SB 11/07/07

Self now PE 2

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

↓
8/11/07/15

bro

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3199-4 PAR #: _____ Fault Category: DESIGN NCR: Yes No DQA: ✓ Date: 11/09/19
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: ✓ Date: 11-07-20

WORK ORDER NON-CONFORMANCE (NCR)

NCR: <u>B31615 PE1</u>		10.76						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11.07.07</u>	<u>130</u>	<u>PARTS GOWG TO PEZ</u> <u>TO REFLECT WHAT CUSTOMER</u> <u>WANTS.</u> <u>RC: MISUNDERSTANDING / NOTES NOT CLEAR</u>	<u>↓</u> <u>12.07.18</u>	<u>SCRAP + DESTROY</u>	<u>SS</u> <u>11/07/15</u>	<u>S</u> <u>11/07/15</u>	<u>↓</u> <u>11.07.16</u>	<u>S</u> <u>11/07/15</u>

NOTE: Date & initial all entries

Work Order ID 71619

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Page 3

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Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____




QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____								
160 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
170 	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									

mr
11-07-15

Work Order ID 71619

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Page 4

Item ID: D3199-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket, Fwd RH

Start Date: 7/7/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALLEFFECTIVE 6/27/07 AUTH RELEASED DATE

DART AEROSPACE LTD	Work Order: 7169
Description: BLACK FWD RH	Part Number: D3199-4
Inspection Dwg: D3199-4, Rev: DE1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.295	$\frac{+}{-}$.010	.292	2		V	B-2
.615	$\frac{+}{-}$.010	.620	2		V	
.508	$\frac{+}{-}$.010	.499	2		V	
2.750	$\frac{+}{-}$.010	2.753	2		V	
4.030	$\frac{+}{-}$.010	4.027	2		V	
1.150	$\frac{+}{-}$.010	1.149	2		V	
3.04	$\frac{+}{-}$.030	3.042	2		V	
3.64	$\frac{+}{-}$.030	3.637	2		V	
3.64	$\frac{+}{-}$.030	3.637	2		V	
4.02	$\frac{+}{-}$.030	4.02	2		V	
.040	$\frac{+}{-}$.010	.036	X		V	

Measured by:	B
Date:	11-7-7


Prototype Approval:	
Date:	

Rev	Date -	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	7/6/9
Description: Bracket		Part Number:	D3195-B (Bent)
Inspection Dwg: D3195 Rev: DE1		Page 1 of 1	

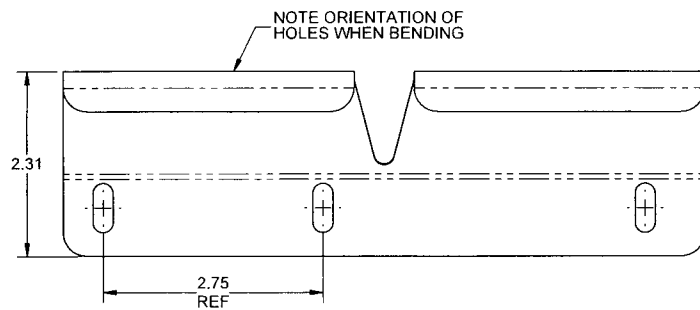
☒ **First Article** ☐ **Prototype**

[illegible]

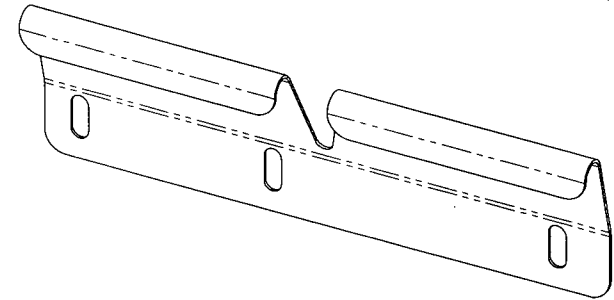
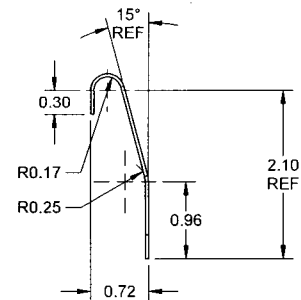
Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:	11/02/08	Date:	N/A

1 PEI Day only

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3199-3 BRACKET
MADE FROM D3199-3F

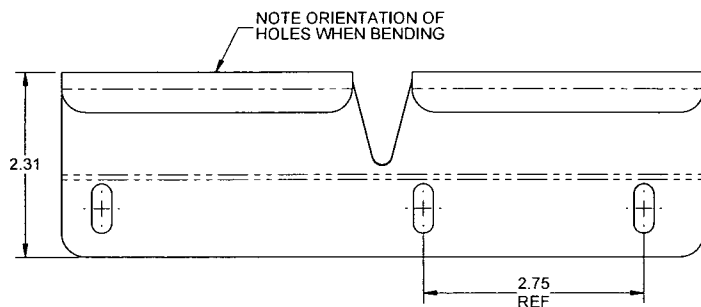


PRELIMINARY ISSUE

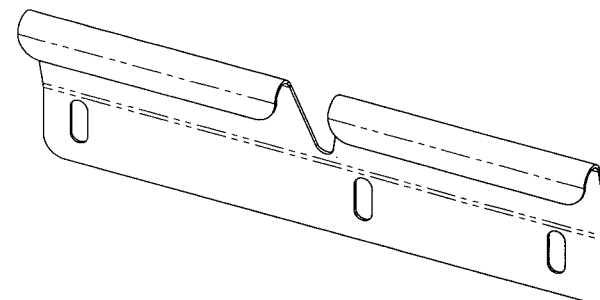
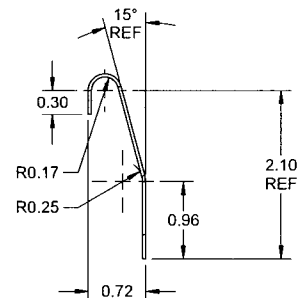
11.07.05

also 76619

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3199	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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D3199-4 BRACKET
MADE FROM D3199-3F

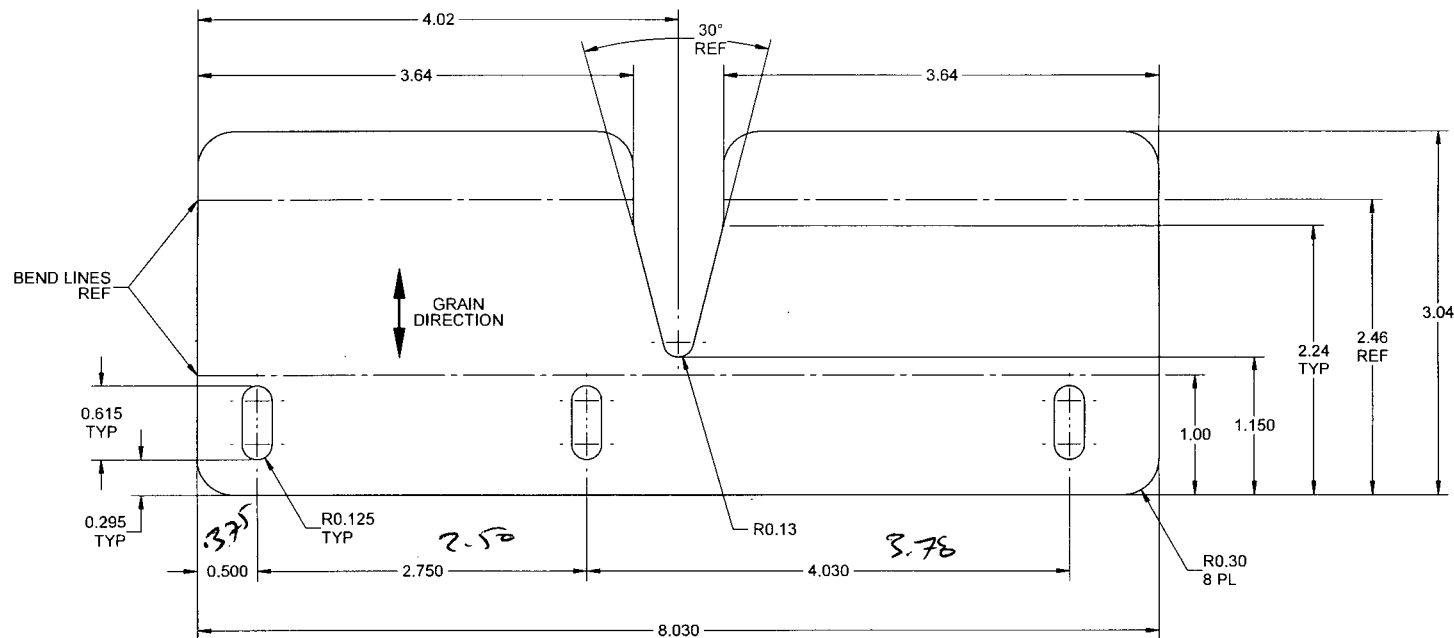


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71619

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PE1 **D3199-3F FLAT PATTERN**

PRELIMINARY ISSUE

11.07.05

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs

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Linda Lacelle

From: Marc Bellavance <mbellavance@dartaero.com>
Sent: July 6, 2011 4:17 PM
To: Lacelle, Linda; Menard, Jean-Luc
Cc: Charbonneau, Eric; Duval, David; Shepherd, David; Petsche, Mike
Subject: D3199-3/-4/-3F Bracket


Hi Linda,

I put a copy of D3199_RevPE1 and DXF for D3199-3F here: [O:\Preliminary\D3199_RevPE1](#)

As per David, we are to make a set for DND for them to test. This should be the final tweak to this bracket.
No charge order for DSI-9484-027/-028 to follow.

Thanks,



 Please consider your
environmental responsibility
before printing this e-mail

Marc Bellavance
Technical/Shop Support
Tel: 613-632-5200 Ext. 243
Cel: 613-676-0992
Fax: 613-632-9311

Product Documentation: Verify Revision Status/Download [HERE!](#)

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DXF's
JL

Linda Lacelle

From: Jean-Luc Menard <jmenard@dartaero.com>
Sent: July 7, 2011 8:43 AM
To: 'Linda Lacelle'; 'Marc Bellavance'
Cc: 'Charbonneau, Eric'; 'Duval, David'; 'Shepherd, David'; 'Petsche, Mike'
Subject: RE: D3199-3/-4/-3F Bracket

Ready to go, the prog is on Hanks prel usb.
JLM

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: July 7, 2011 6:54 AM
To: 'Marc Bellavance'; 'Menard, Jean-Luc'
Cc: 'Charbonneau, Eric'; 'Duval, David'; 'Shepherd, David'; 'Petsche, Mike'
Subject: RE: D3199-3/-4/-3F Bracket

JL, let me know when good to proceed...
LL

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
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